

AMENDMENTS TO THE CLAIMS

1. (Currently Amended) A method for producing a cover made of a special steel blank which can be deep-drawn and placed on ~~[[the]]~~ an end of a motor vehicle exhaust pipe, ~~characterized by the combination of the method steps directly following each other and including:~~

- a) making a circular blank (10) ~~is made from a special steel plate,~~
- b) drawing in a plurality of deep-drawing operations a plurality of cup-shaped beakers (10.1, 10.2, 10.3, 10.4) each with a bottom (11.4), ~~which is inclined~~ inclined ~~[[in]]~~ with respect to ~~[[the]]~~ a longitudinal axis (25), ~~wherein the~~ and having diameters (D1, D2, D3, D4) that are uniform over ~~[[the]]~~ an entire shell length (L1, L2, L3, L4)~~[[,]]~~ but are more and more decreased~~[[,]]~~ and the shell lengths (L1, L2, L3, L4), ~~however, are more and more increased, are drawn in several deep-drawing operations,~~
- c) punching into the bottom (11.4) a centered hole (13) with a rim (14) which is ring-shaped toward ~~[[the]]~~ a shell (12.4) ~~is punched into the bottom (11.4),~~
- d) cutting the shell (12.4) ~~is cut~~ vertically ~~[[in]]~~ with respect to the longitudinal axis (25) of the beaker (10.4) to ~~[[the]]~~ a required length (Lo) and cutting a condensate drain opening (16) and a fastening hole ~~are cut~~ into the shell (12.5),

Based Upon: PCT/EP03/01290

e) bending the rim (14) of the bottom (11.4) ~~is bent in~~ parallel ~~[[in]]~~ with respect to the longitudinal axis (25) and ~~[[is]]~~ subsequently ~~crimped~~ crimping into the beaker (10.6) to form an end (17) shaped as ~~in the shape of~~ an arc of a circle, and

f) ~~at the finish the~~ tapering an end section (18) on the cut open front (15) of the beaker (10.7) ~~is tapered~~ for decreasing the diameter.

2. (Currently Amended) The method in accordance with claim 1, wherein a ~~characterized in that the~~ transition from the inclined bottom (11.1 to 11.6) to the shell (12.1 to 12.5) of the ~~various~~ deep-drawing steps operations is ~~always~~ rounded.

3. (Currently Amended) The method in accordance with claim ~~[[1 or]]~~ 2, wherein ~~characterized in that~~ the bottom (11.1 to 11.6) ~~[[in]]~~ with respect to the shell (12. 1 to 12.5) of the ~~various~~ deep-drawing steps operations is inclined on a diameter of approximately 70° or 110° ~~in relation~~ relative to the longitudinal axis (25).

Based Upon: PCT/EP03/01290

4. (Currently Amended) The method in accordance with ~~one of claims 1 to claim 3, wherein characterized in that~~ cutting off the shell (12.4) to the required length (Lo) and cutting at least one of the condensate drain opening (16) ~~and/or~~ and the fastening hole are performed together.

5. (Currently Amended) The method in accordance with ~~one of claims 1 to claim 4, wherein characterized in that~~ the bore (13) in the bottom (11.5) is shaved (13.1) prior to crimping the end (15) in the shape of ~~[[an]]~~ the arc of ~~[[a]]~~ the circle.

6. (Currently Amended) A cover, produced in accordance with the method of ~~claims 1 to claim 5, characterized in that~~ crimped in the shape of ~~[[an]]~~ the arc of ~~[[a]]~~ the circle, ~~[[and]]~~ wherein ~~[[the]]~~ an other front face (15) which extends perpendicularly ~~[[in]]~~ with respect to the longitudinal axis (25) in ~~[[the]]~~ an adjoining section (18) has a diameter ~~which is~~ smaller than the diameter (D4) of the remaining shell (12.4).

Based Upon: PCT/EP03/01290

7. (New) A cover, produced in accordance with the method of claim 1, crimped in the shape of the arc of the circle, wherein an other front face (15) which extends perpendicularly with respect to the longitudinal axis (25) in an adjoining section (18) has a diameter smaller than the diameter (D4) of the remaining shell (12.4).

8. (New) The method in accordance with claim 1, wherein the bottom (11.1 to 11.6) with respect to the shell (12. 1 to 12.5) of the deep-drawing operations is inclined on a diameter of approximately 70° or 110° relative to the longitudinal axis (25).

9. (New) The method in accordance with claim 1, wherein cutting off the shell (12.4) to the required length (Lo) and cutting at least one of the condensate drain opening (16) and the fastening hole are performed together.

10. (New) The method in accordance with claim 1, wherein the bore (13) in the bottom (11.5) is shaved (13.1) prior to crimping the end (15) in the shape of the arc of the circle.